

November-15-11 8:10:37 AM

Page 1

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

76466

Page 2

N900040100

Setup Start ***NS1***

Stop *NS2*

Start Date: 15/11/2011 **Start Qty:** 4.00 ***4***

Cust Item ID:

Required Date: 29/11/2011 **Req'd Qty:** 4.00 ***A***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

**Insp.
Stamp**

0.00

120

QC

Memo

0.00

Quality Control

0.00

130

Brake NC

Memo

0.00

Brake NC

0.00

140

QC

Memo

0.00

Quality Control

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NOTE: Date & initial all entries

Work Order ID 76466***76466***

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November-15-11 8:10:37 AM

Item ID: D3254-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Side (LH)

Start Date: 15/11/2011 Start Qty: 4.00

4

Cust Item ID:

Required Date: 29/11/2011 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150 Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

4 26120-4

151 QC3- Inspect Part Finish

0.00

151

QC

Memo

0.00

Quality Control

4x 12/06/05

153 0.00

153

Small Fab

Memo

0.00

Small Fab

Install D3248-1 as per dwg

4x 12/06/05

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 76466

76466

Page 4

November-15-11 8:10:37 AM

Item ID: D3254-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Side (LH)
 Start Date: 15/11/2011 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 29/11/2011 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

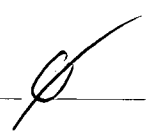
Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

157	QC5- Inspect part completeness to step on W/O	0.00							
157									
QC	Memo	0.00							
Quality Control									

170	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
170									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 11:30 OVEN TEMPERATURE: 320 °F FINISH TIME: 12:00								

180	QC3- Inspect Part Finish	0.00							
180									
QC	Memo	0.00							
Quality Control									

M121279

4X  12/06/05

4 x  12/06/05

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Work Order ID 76466

76466

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November-15-11 8:10:37 AM

Item ID: D3254-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Side (LH)
 Start Date: 15/11/2011 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 29/11/2011 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location 144	0.00							
190									
Packaging	Memo	0.00				(4x)		12/6/11	mf
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.00							
Quality Control									

12-06-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 76466

76466

Parent Item: D3254-041

D3254-041

Parent Item Name: Side (LH)

Start Date: 15/11/2011

Required Date: 29/11/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP B 04.10.26 D3254-1 no longer made in-house
11.02.07 made on W.J. DD verf:JLM

IPP Rev:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			100	sf	33.5000	3.3609	13.4436			
M2024T3S.063									**				
2024-T3.063 sheet													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT022		33.5							
				117392		33.5							
D3248-1		Manufactured	No			153	Each	15.0000	2	8			
D3248-1									**				
Doubler													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST044		15							
				66195		3							
				66555		12							
MS20470AD4-5		Purchased	No			153	Each	2,424.000	18	72			
MS20470AD4-5									**				
Rivet, Universal Head													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST319		2424							
				116893		68							
				118405		2356							

14
B12-5-30
(4)
119916
8
12/06/05
8
72
12/06/05
72

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 76466
Description: Side (Dual Battery Rack)		Part Number: D3254-2
Inspection Dwg: D3254	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.20	+/-0.030	5.20	2		V BoL	
4.15	+/-0.030	4.144	2		V	
R0.19	+/-0.030	.19	2		R.G.	
1.103	+/-0.010	1.104	2		V	
0.300	+/-0.010	.299	1		V	
Ø0.098	+0.005/-0.000	.102	2		V	
1.300 Pitch	+/-0.005	1.303	2		V	
21.056	+/-0.010	21.056	2		T BoL	
19.000	+/-0.010	19.00	2		T	
1.003	+/-0.010	1.005	2		V	
Ø1.125	+0.005/-0.000	1.05	2		V	
5.403	+/-0.010	5.400	2		V	
Ø1.500	+0.005/-0.000	1.500	2		V	
2.750 Pitch	+/-0.005	2.752	2		V	
5.500	+/-0.010	5.499	2		V	
1.653	+/-0.010	1.661	2		V	
3.75	+/-0.030	3.740	2		V	
10.810	+/-0.010	10.806	2		V	
8.00	+/-0.030	7.994	2		PROW502	
R0.50	+/-0.030	.50	2		R.G.	
2.750 Pitch	+/-0.005	2.746	2		V	
4.125	+/-0.010	4.128	2		V	
22.946	+/-0.010	22.946	2		T	
R0.30	+/-0.030	.30	2		R.G.	
9.90	+/-0.030	9.910	2		P	
11.77	+/-0.030	11.777	2		P	
1.82	+/-0.030	1.817	2		V	
2.17	+/-0.030	2.168	2		V	
20.10	+/-0.030	20.10	2		T	
0.953	+/-0.010	.953	2		V	
R0.125	+/-0.010	.125	2		R.G.	
Grain along 20.10	N/A		2			

Measured by: B	Audited by: n/n	Prototype Approval:	N/A
Date: 12-5-30	Date: 12.05.30	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.07.07	New Issue	KJ/JLM	

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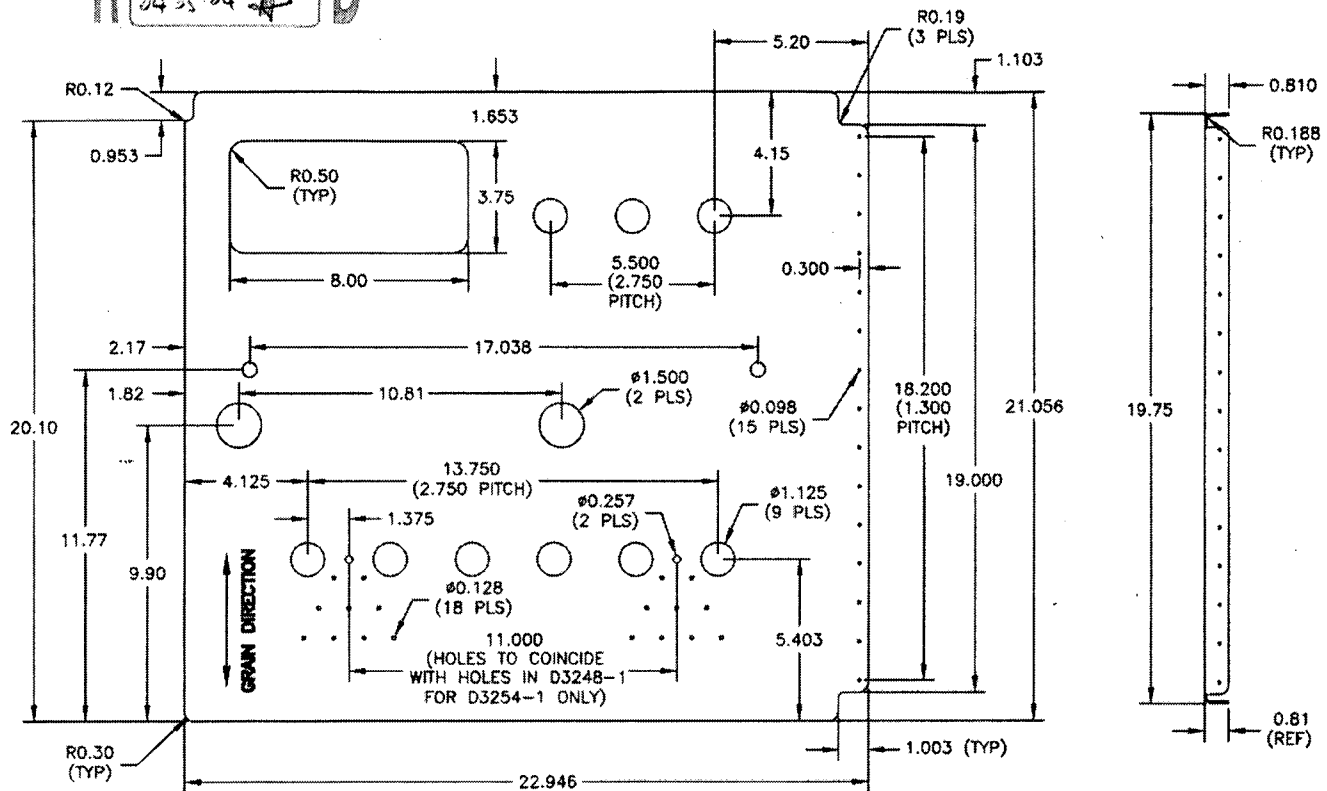
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DART

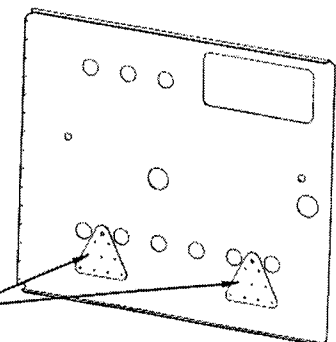
DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3254	REV. A SHEET 1 OF 1
DATE 04.04.06		TITLE SIDE (DUAL BATTERY RACK)	SCALE 1:6
A	04.04.06	NEW ISSUE	

RELEASED
04-25-04**D3254-1/-2 FLAT PATTERN**

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 76466 M.C.5
11/11/15

**D3254-1 BEND DETAIL (SHOWN)
D3254-2 OPPOSITE**

INSTALL D3248-1
USING MS20470A4-5
RIVETS

**D3254-041****NOTES:**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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